

Work Order ID 52033

September 14, 2009 9:23:41 AM



Page 1

Item ID: D2137

Accept



Setup Start



Revision ID:

Stop



Item Name: Decal - No Step

Start Date: 9/14/09 Start Qty: 30.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O 10395
Make per Dwg 2137

CL 09/09/14 30

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 9/9/08 30

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

2) 8/02/09/121

counts
(430) 4

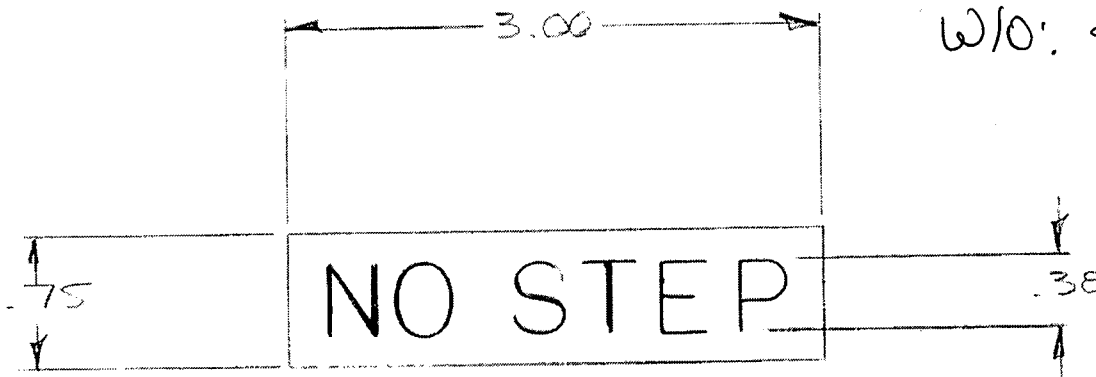
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ALTERNATE MATERIAL:

3M 7 MIL MASKING FILM #8522CP

SILVER OR WHITE ON BLACK

CL 09/09/14
CP 00-2000

MATERIAL: 3M POLYESTER

NATURAL (SILVER OR
WHITE) ON BLACK.

.003 THICK



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENDOR	
DRAWN				BASIC CODE		DIA. DASH NO. H-HEAD NEAR SIDE F-HEAD FAR SIDE		CONTRACT NO.		DRAWN		DATE		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA	
APPROVED				D-DIMPLE D-DIMPLE NO OF SHEETS C-COUNTERSINK		LENGTH DASH NO W-SPOTWELD		DESIGN		43					
DESCRIPTION		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES				STRESS				TITLE		DECAL - NO STEP	
OF		GENERAL		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125-4 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 32 5. HOLES PER AND 10387		1. TOLERANCES — .001 & .002 2. ANGLES 3. PARALLELISM 4. ECCENTRICITY 5. SYMMETRY ABOUT ALL MAT. CENTRE LINES .005		8J-M570470AD 8B-M570476AD		CHECKED				CODE	
CHANGE		LIMITS						CLIENT				DWC NO		D 2137	
												SCALE		SHEET 1 OF 1	
REPORT ALL DISCREPANCIES — DO NOT SCALE															



210 MAIN W.,
HAWKESBURY, ONT. K6A 2H6

Tel.: 613 632-2001

Fax: 613 632-9491

www.studiolettrage.com

INVOICE / FACTURE

No.:

12750

DATE:

09/18/2009

PAGE

1 of 1

Re: Quote No. 7610

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AM MONT
	30 1		D2137 printing set up E - GST @ 5% G - GST @ 5%; PST @ 8% GST PST Exempt: #6122-5207 S 11 02/01/21	G E		1.6667 50.0000	5/ 5/
Studio de Lettrage GST: #869034678RP001 PO 10395						TOTAL	10/

Sold By:

Merci! Thank You!



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10395**

Purchase Order Date 9/14/09

PO Print Date 9/14/09

Page Number 1 of 1

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA



Contact Name

Vendor Phone

613 632 5449

Vendor Fax

613 632 9491

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2137P	Decal - No Step	9/18/09 Yes	30.00 Each		\$5.0000 \$ 3.33	\$150.00

Special Inst: AS PER DWG D2137 REV. 00-09-05
B52033

PO Total:

\$150.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

CZ

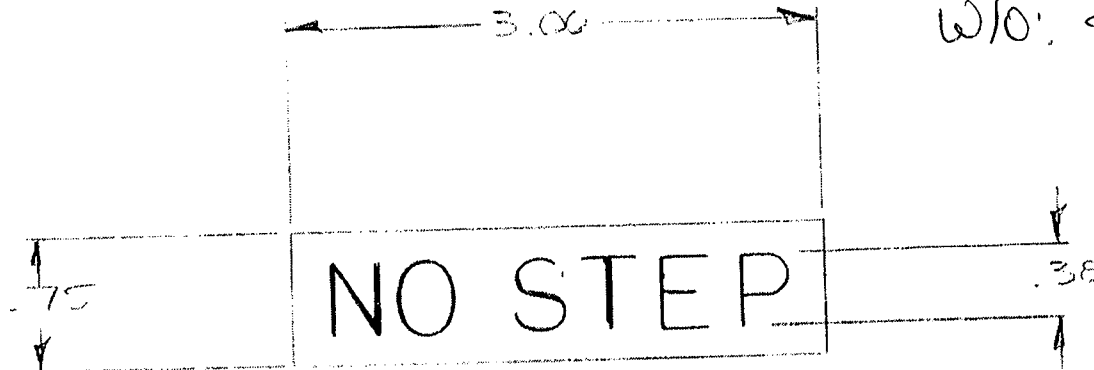
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr:

1

Change Date: 9/14/09

C/L 09/09/114
W/O: S2033



REFERENCE ONLY

ALTERNATE MATERIAL:
3M 7 mil MAGNOLIA ADHESIVE
SILVER OR WHITE OR BLACK

MATERIAL: 3M POLYESTER
NATURAL (SILVER OR
WHITE) OR BLACK
.003 THICK



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 573		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC. VENDOR	
DRAWN				BASIC CODE		CONTRACT NO.				DATE		DART		DART AERO ACCESSORIES INC. CANADA	
APPROVED				D-COMPLY DIGIT NO OF SHEETS C-COUNTERS PER		DESIGN		STRESS		CHECKED		CLIENT			
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 5-7747 5. HOLES PER AND 10287 1. TOLERANCES — .001 & .030 2. ANGLES .010 3. PARALLELISM .005 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL BASIC CENTRE LINES .005		BASIC CODES 8J-M52047040 8B-M52047040		LENGTH DASH NO W-SPOTWELD		TITLE DECAL - NO STEP		CODE D2137		DMC NO 111		REV 1 OF 1	
REPORT ALL DISCREPANCIES — DO NOT SCALE															



Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www.scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminates 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

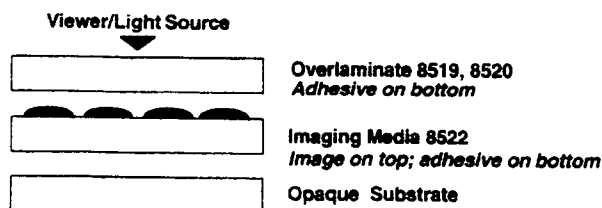
Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.




Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768
International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
Product Bulletins		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
Instruction Bulletins		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
Warranties		
Worldwide 3M™ MCS™ Warranty Packet <i>(includes all Commercial Graphics MCS Warranties)</i>		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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Epson and Stylus Pro are trademarks of Epson.
HP and DesignJet are tradenames of Hewlett Packard.
Sintra is a trademark of Swiss Aluminum Ltd.
Intron is a registered trademark of DuPont in the United States

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.

3M

Commercial Graphics Division

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St. Paul, MN 55133-3220 USA
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Technical Info. 1-800-328-3908
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Fax-on-Demand document: 4506
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Fax 519-452-6245

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México, D.F. 01210
52-55-52-70-04-00
Fax 52-55-52-70-22-77

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